

Date: Monday, 28/05/2007 2:25:21 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WINDOW
Job Number	: 32366		
Estimate Number	: 11176		
P.O. Number	: <i>N/A</i>	Part Number	: D32903
This Issue	: 28/05/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3290 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 16/05/2007 Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 29568	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 22/05/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	10 Um: Each
Comment	: Est. A 04.08.18 New issue KJ/RF Est. B 06.05.09 Ecn 798 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	THERMOFORMING	THERMOFORMING MACHINE
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*7103735*

Comment: THERMOFORMING MACHINE
MAKE PER DRWG D3290 REV.B

2.0	MACRLICS125	1/8" Polycast II Sheet
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Comment: Qty.: 3.0800 sf(s)/Unit Total: 30.8000 sf(s)
1/8" Polycast II Sheet

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: DIMENSIONAL CHECK
Inspect dimensions as per Dwg D3290 and DT3290-3T1

*For 06.20**(PTC)*

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

07/6/21 (10)

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

*07/06/22**(K)*

Job Completion

*07/06/22*

21

Date: Wednesday, 5/16/2007 8:11:04 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WINDOW
 Job Number : 32366
 Estimate Number : 11176
 P.O. Number :
 This Issue : 5/16/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D32903
 Drawing Number : D3290 REV B
 Project Number : N/A
 First Issue : / / Type : PURCHASED PARTS Drawing Revision : B
 Material :
 Previous Run : 29568 Due Date : 5/22/2007 Qty: 10 Um: Each
 Written By :
 Checked & Approved By : *Kim Johnston*
 Comment : Est. A 04.08.18 New issue KJ/RF
 Est. B 06.05.09 Ecn 798 EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: _____

Description: D3290-3 Window

Possible Supplier: Canus

Certificate of Conformity & Process sheet are required

2.0

D32903P

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
 Window

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity and process sheet are attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3290 and DT3290-3T1

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-07-20	3.0	1 window scrap. very wavy in the middle of the view/window. R.C.: Bad forming/heat distortion.	<i>[Signature]</i>	Scrap i. destroy	<i>Ep</i> 07/06/20	<i>[Signature]</i> 07-06-20	<i>[Signature]</i> 07-06-20	<i>[Signature]</i> 07-06-20

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW

Job Number: 32366

Part Number: D32903

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



10

Comment: FINAL INSPECTION/W/O RELEASE

07/06/04

Job Completion



Machine .125" ~~M103735~~

- 1) Mark Trim part as per jig DT 3290 - 371 07/06/04
- 2) DRAPE Mould part as per Aug. D3290-3 Rev B incl FOLIO F1A000 07/06/04
- 3) Inspect Parts QC 22 07/06/04
- 4) Retrain Parts - (Parts re-trained to meet allowable tolerances) 07/06/04
- 5) R-inspect parts 07/06/04

QC 5.
Resort 2 windows 07/06/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

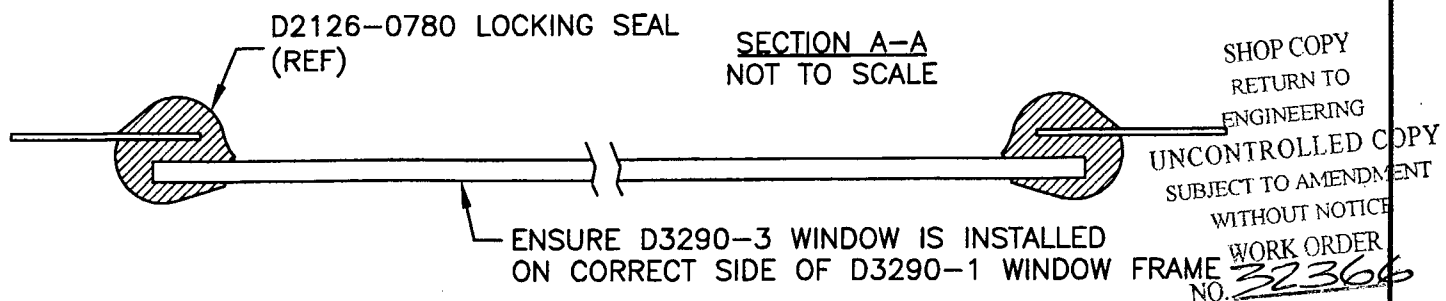
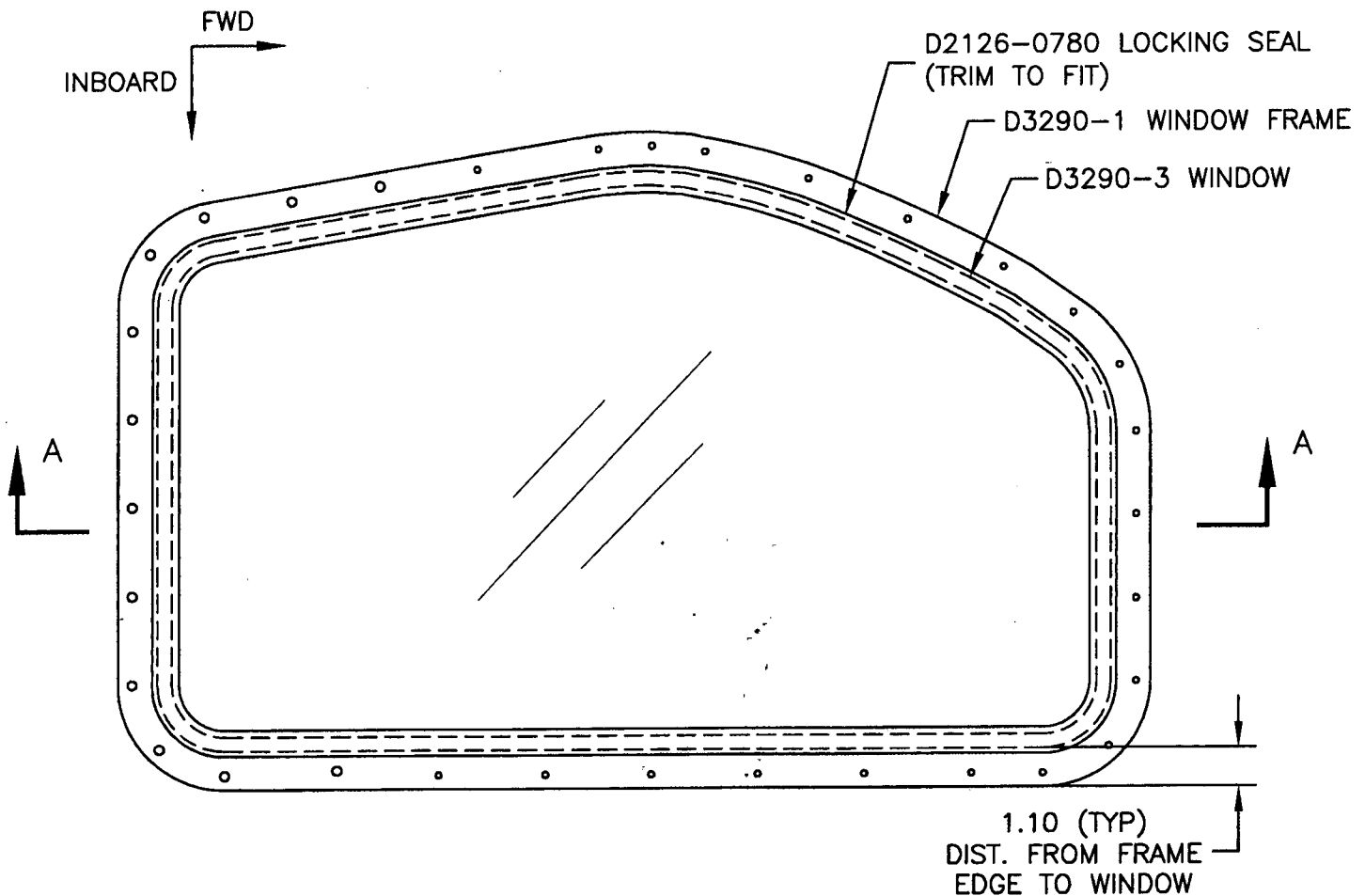
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290	REV. B SHEET 1 OF 3
DATE 06.04.20	TITLE REPLACEMENT WINDOW ASSEMBLY		SCALE 1:5
A	04.06.14	NEW ISSUE	
B	06.04.20	UPDATE MATERIAL PER NCR 029	



D3290-041

NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

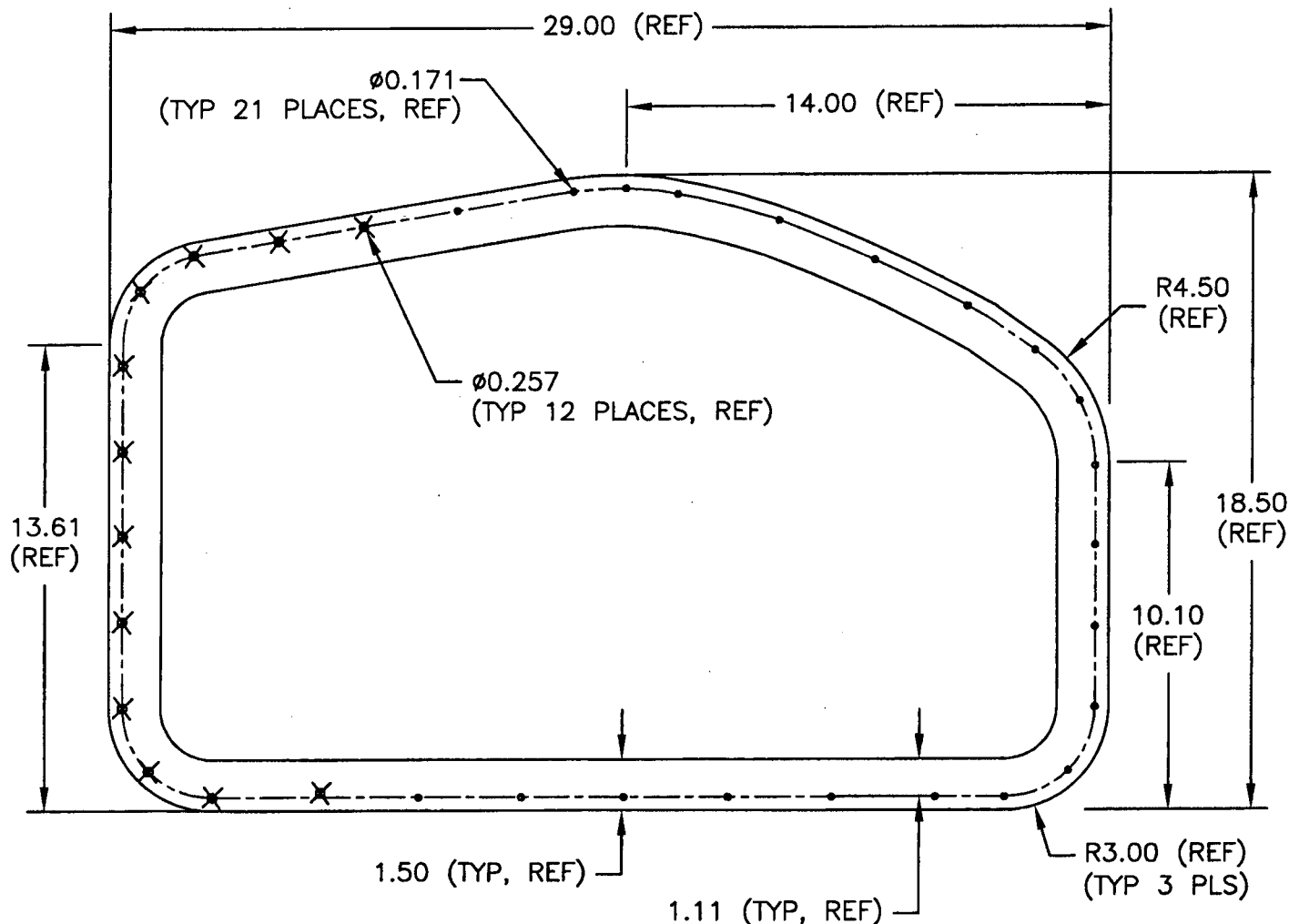
06.04.20 *[Signature]*

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CHECKED 	APPROVED 	DRAWING NO. D3290	REV. B SHEET 2 OF 3
DATE 06.04.20	TITLE REPLACEMENT WINDOW ASSEMBLY		SCALE 1:5



D3290-1 FRAME

D3290-1

- 1) MACHINE PER DRAWING FILE "D3290-A2.DWG"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) SHEET 0.040 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

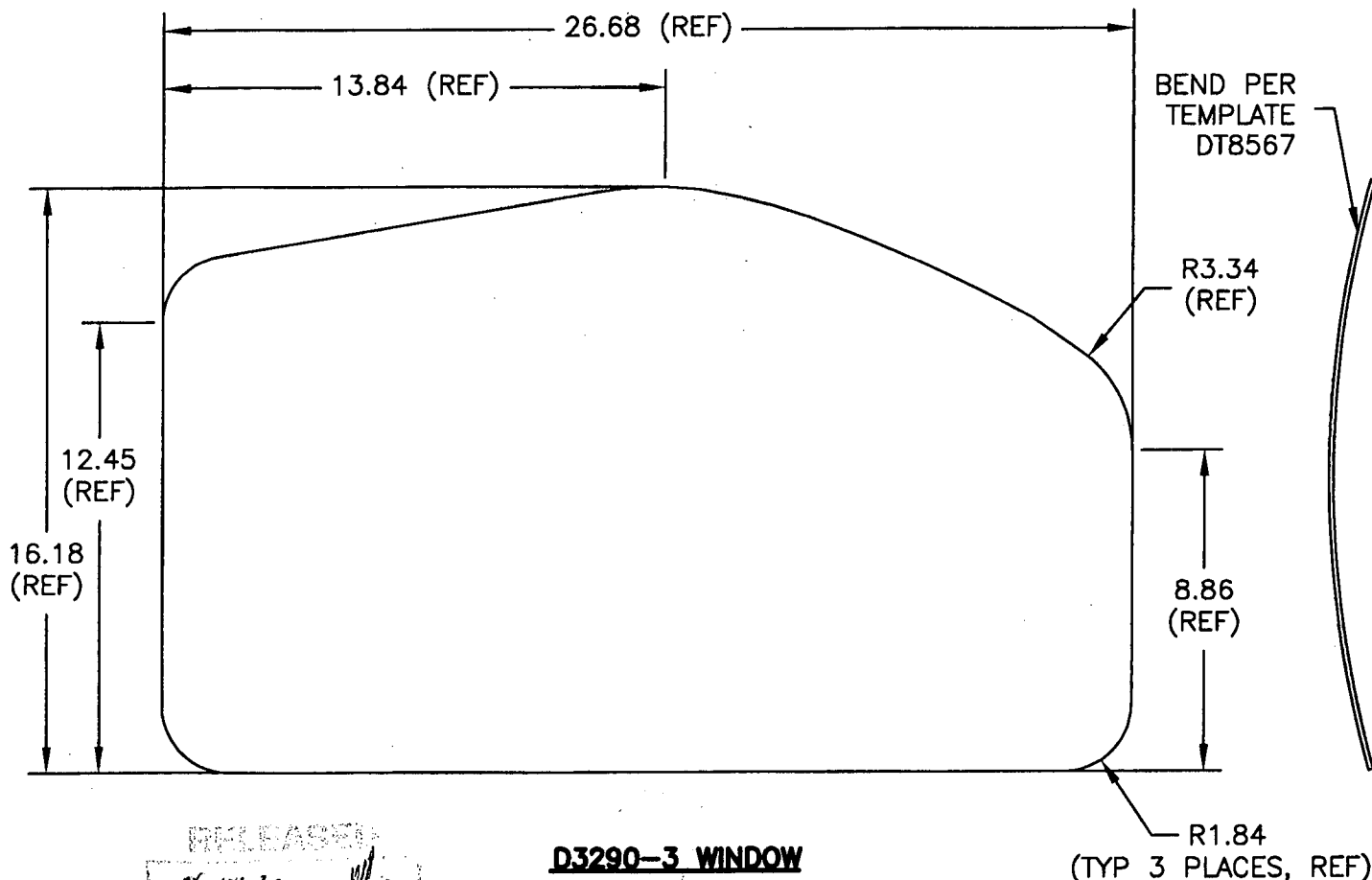
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06.04.20
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290	REV. B SHEET 3 OF 3
DATE 06.04.20		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5

**D3290-3**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) CHECK PART USING DT3290-3T1

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